

Work Order ID 119943

May-30-14 8:43:02 AM

119943

Page 1

Item ID: D4628-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Liner, Inboard

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-05-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4628 | A | | | | | | | | |

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4628

Prog rev: A

Dwg rev: A

2-Deburr as per dwg

1 0 Jm 14-05-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1 0 Jm 14-05-30

Work Order ID 119943

May-30-14 8:43:02 AM

119943

Page 2

| | | | | | | |
|----------------|----------------|-----------------|---------------------|---------------|-------|--------------|
| Item ID: | D4628-3 | Accept | *N900040100* | Setup | Start | *NS1* |
| Revision ID: | | | | | Stop | *NS2* |
| Item Name: | Liner, Inboard | | | | | |
| Start Date: | 5/30/14 | Start Qty: 1.00 | *1* | Cust Item ID: | | |
| Required Date: | 5/30/14 | Req'd Qty: 1.00 | *1* | Customer: | | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14/6/2 (1) DAS
32
3-89
 MLJ 14-06-03
 MF
 14-6-02

Picklist Print

May-30-14 8:43:05 AM

Page 1
f

Work Order ID: 119943

119943

Parent Item: D4628-3

D4628-3

Parent Item Name: Liner, Inboard

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MKYD6185S.080-P3-52068 | | Purchased | No | | | 100 | sf | 2,739.000 | 6.6 | 7 | | | |

MKYD6185S 080-P3-52068

Jm14-05-30

Kydex steel grey (52"x96"-.080)

Location

Loc Qty

Loc Code

therm

2739

119476

61

121902

909

122181

1075

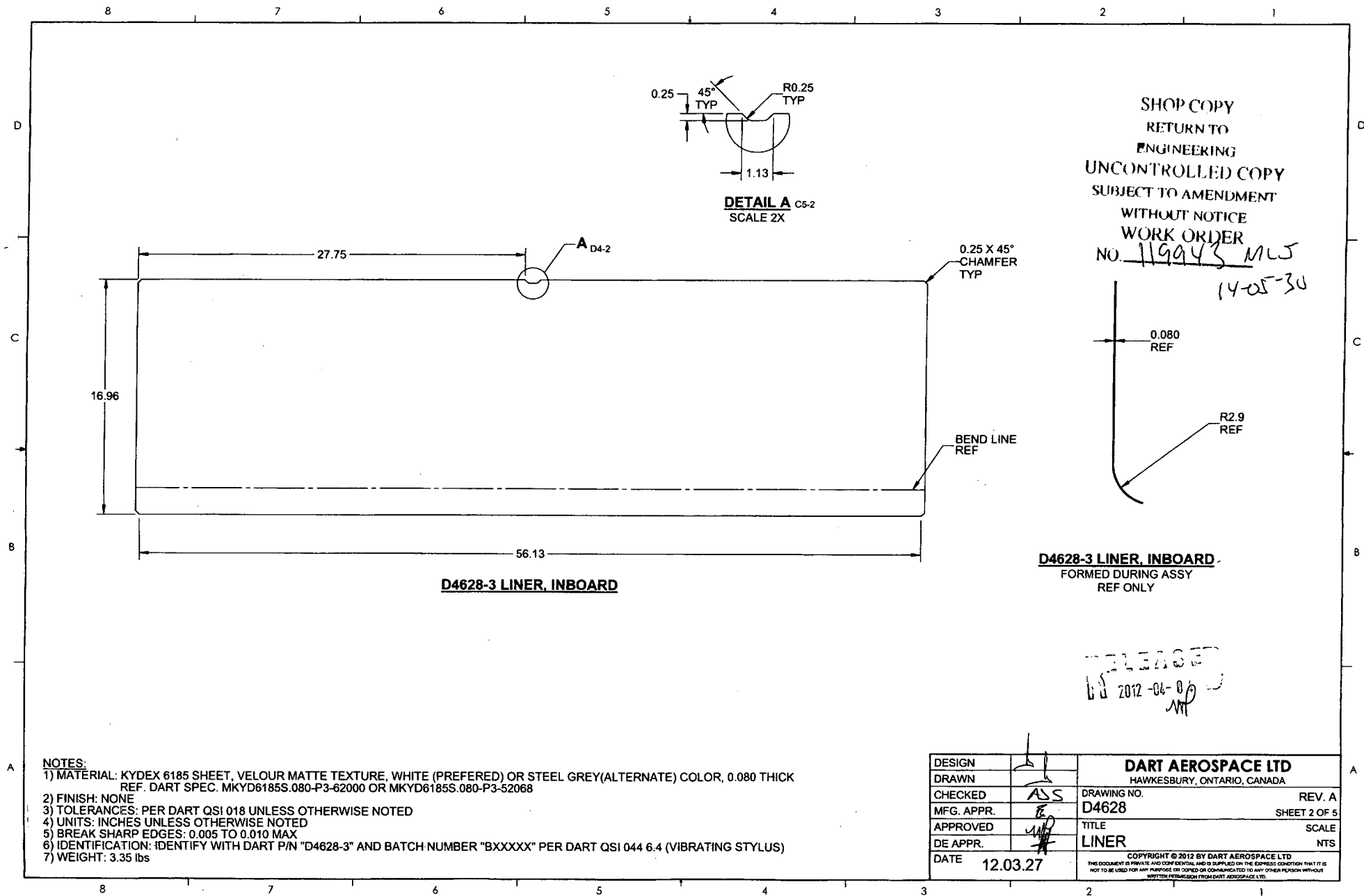
m127759

347

m128321

347

122181






SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119943 MLJ
14-05-30

D4628-3 LINER, INBOARD
FORMED DURING ASSY
REF ONLY

RELEASED
12 2012 -06-08

- NOTES:
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-3" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 3.35 lbs

| | | | |
|------------|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. A |
| MFG. APPR. | E | D4628 | SHEET 2 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | LINER | NTS |
| DATE | 12.03.27 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |